



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6522A00231-W142AJ-

3T-5A

Job Sheet 199141



Part No: RBW6522A00231-W142AJ-3T-5A Job Qty: 1 pcs

Part Name: Insert



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/13/19

Job Tracking No:

Due Date: 10/7/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6522A00231-W142AJ-3T Rev 5 IPP Rev A 18.02.12 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	SL-2500Y - 1	1 pcs	10/7/19	10/7/19	1.50	0.25	SL-2500Y - 1		SL 19-9-8
130	QC 2	1 pcs	10/7/19	10/7/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		SL
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

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8/13/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

					QC 2 - 5		
					QC 2 - 71		
					QC 2 - 73		
					QC 2 - 69		
140	NV5000 - 2 - B4B	1 pcs	10/7/19	0.50 0.25	NV5000 - 1 - B4B	ALA. / ml	19-09-15
					NV5000 - 2 - B4B		
150	QC 2	1 pcs	10/7/19	0.00 0.00	QC 2 - 1		
					QC 2 - 12		
					QC 2 - 14	ALA. / ml	19-09-15
					QC 2 - 17		
					QC 2 - 19		
					QC 2 - 2		
					QC 2 - 20		
					QC 2 - 22		
					QC 2 - 23		
					QC 2 - 25		
					QC 2 - 32		
					QC 2 - 33		
					QC 2 - 35		
					QC 2 - 39		
					QC 2 - 4		
					QC 2 - 40		
					QC 2 - 44		
					QC 2 - 45		
					QC 2 - 48		
					QC 2 - 49		
					QC 2 - 50		
					QC 2 - 51		
					QC 2 - 52		
					QC 2 - 57		
					QC 2 - 62		
					QC 2 - 63		
					QC 2 - 8		
					QC 2 - 66		
					QC 2 - 64		
					QC 2 - 65		
					QC 2 - 5		
					QC 2 - 71		
					QC 2 - 73		
					QC 2 - 69		
160	QC 8	1 pcs	10/7/19	0.00 0.00	QC 8 - 12		
					QC 8 - 14		
					QC 8 - 17		
					QC 8 - 20		
					QC 8 - 25		
					QC 8 - 3		
					QC 8 - 32		
					QC 8 - 33		
					QC 8 - 35		
					QC 8 - 39		
					QC 8 - 4		
					QC 8 - 44		
					QC 8 - 45		
					QC 8 - 49		
					QC 8 - 58		
					QC 8 - 8	B. 19-09-21	
					QC 8 - 9		
					QC 8 - 68		
					QC 8 - 67		

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					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
200	Outsource - 12 - Black Oxide	1 pcs	10/7/19	0.00 0.00	GR002	2019-09-23
210	Packaging 2-1 - Receive - B4B	1 pcs	10/7/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
220	QC 6	1 pcs	10/7/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
230	Packaging 3-1 - Stock - B4B	1 pcs	10/7/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
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6/13/2019

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				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
240	QC 21 - SA	1 pcs	10/7/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

DAS
21

OCT 03

019

GA

170

Part Op 120 - (MORI SL2500Y LATHE) 1-Machine as per folio FB LC961 FOLIO REV: AA DWG REV: 21

Descriptions: 5 2-Debur

130 - (QC2- Inspect parts off machine FAI/FAIB)

140 - NV5000-2 (MORI SEIKI VERTICAL MACHINE #2) 1-Machine as per folio FB LC961 FOLIO REV: AA

DWG REV: 5 2-Debur

150 - (QC2- Inspect parts off machine FAI/FAIB)

160 - (QC8- Inspect parts - second check)

200 - (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; PO 44559 -Black oxide finish, MIL-C-13924C

Class 1 -Certificate of Conformity is required

210 - (Receive & Inspect for Damage & Mat'l Certs)

220 - (QC6- All purchased or subcontracted products)

230 - (Identify as per dwg & Stock Location: _____)

240 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R2.750	AISI 4140 Quenched & Tempered Steel Round Bar 2.750" Dia.	.1100 ft (.11 ea)	120-SL-2500Y - 1	<u>5124465-880</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-SL-2500Y - 1	MT-4140QT-R2.750	0	12	0

Part Specifications

Specifications could not be found.

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
1		-5A CHD DIM WAS Ø2.5215-2.5208 IS Ø2.5185 +.0005-.0005. WAS Ø1.5730-1.5724.	9/28/2012	RJC
2	15-0172	-5A CHD DIM WAS M6 X 1 J .433 ∇ .236 (3X) IS 3X Ø.252 THRU J .43 ∇ .24.	7/17/2015	RJC
4	16-0250	-5A ADDED HEAT TREAT: ADDED FINISH SPEC.	12/5/2016	SM
				JAG

SHOP COPY

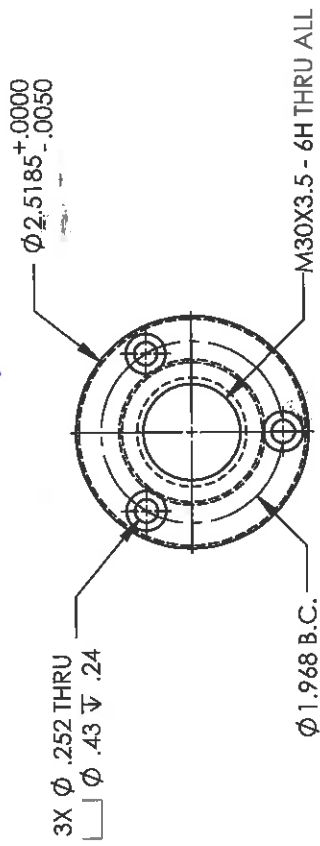
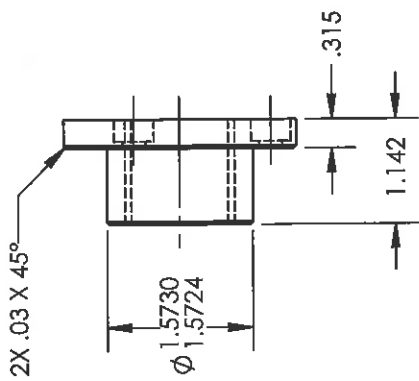
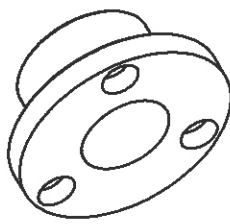
RETURN TO
ENGINEER

UNCONTROLLED

SUBJECT TO ANY
WITHOUT NO.

WORK OR

NO. 199141 MVS
190813



TITLE		TGB/SERVO ACTUATOR OIL SEAL FIT/EXTRACTION TOOL
DWG NO.	RBW6522A00231-W142AJ-3T-5A	REV 5
MAT'L	4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	RC 28-34	DIMENSIONS ARE IN INCHES
FINISH	BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC	QMSI-6.2.2. B.O. REV D	.XX ± .01 ANGLES ± 5°
DRAWN BY:	PERRITT	.X ± .1 SURFACES = 125
CHECKED:	CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR:	ANDERSON	.015 x 45° OR .015R
QA APPR:	LINDSAY	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
APPROVED:	GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE	1:2	USED ON MODEL
DATE	10/5/2010	AW139
		SHEET 5 OF 10

-5A

INSERT



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (Q1042)			
Description Work Order Deviation		Disposition					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY					
		Pressure/Forced Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____		Contamination Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	
		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					
		Completed By _____					
		Lead hand / Supervisor _____					
		QC / QA Coordinator _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044559



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044559
PO Date: 9/23/19
Due Date: 10/1/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pyrm Terms: Net 60
Freight Terms:
Special Comments:

E-MAILED
2019-09-29

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	199047	RBW6510G05731-6F-2	Support -Issue P/O: -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed		10/1/19	6 pcs	0 pcs	6 pcs	\$6.95/pcs	\$41.70
2	199141	RBW6522A00231-W142AJ-3T-5A	Insert (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed		10/1/19	6 pcs	0 pcs	6 pcs	\$2.69/pcs	\$16.14



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PURCHASE ORDER
POHB044559



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	199037	RBW6510G04631-6F-6	Bracket -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed -		10/1/19	12 pcs	0 pcs	12 pcs	\$1.85/pcs	\$22.20
											DP
											SEP 26 2019
4	197520	RBE350A94-2706-00-01	Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed -		10/1/19	50 pcs	0 pcs	50 pcs	\$2.50/pcs	\$125.00
											DP
											SEP 26 2019
5	199255	RBST4241-15	Locating Pin -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed -		10/1/19	12 pcs	0 pcs	12 pcs	\$1.23/pcs	\$14.76
											DP
											SEP 27 2019
Grand Total:											\$219.80

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044559



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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Certificat de Conformité / Certificate of Compliance

(022664-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

022664 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

SEP 26 2019

DART AEROSPACE LTD.

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
26-Sep-2019		Jigar Patel		POHB044559				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBW6510G05731-6F-2 Rev.	RBW6510G05731-6F-2 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE 3 OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	6	6	0	0	0
2	RBW6522A00231-W142AJ-3T-5A Rev.	RBW6522A00231-W142AJ-3T-5A OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	6	6	0	0	0
3	RBW6510G04631-6F-6 Rev.	RBW6510G04631-6F-6 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE 3 OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	12	12	0	0	0
4	RBE350A94-2706-00-01 Rev.	RBE350A94-2706-00-01 SAND BLAST ALL OVER OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	50	50	0	0	0
5	RBST4241-15 Rev.	RBST4241-15 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE 3 OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	12	12	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.